Quality Control

Work Orden Details 17-13		18429		*108429*										
tem ID: Revision ID:	D3015-7			*N900040100* Setup Start										
tem Name:	Lock Nut		10C						Stop	*N:	<b>32</b> *			
Start Date:	10/17/13	<b>Start Qty:</b> 50.00	*50	*	Cust Ite	em ID:								
Required Date:	: 10/17/13	<b>Req'd Qty:</b> 50.00			Custom	er:								
Reference:								_		G4 4				
Approvals:	Process Pl	an: MLJ	Date: 13-10	Z ( Tooling:		Date:		R	Run	Start	*NI	₹1*		
	<b>QC:</b>		Date:	SPC (Y/N):		Date:	·-			Stop	*NI	R2*		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp		
Draw Nbr	Re	vision Nbr												
D3015	Re	v C												
100		PURCHASING		0.00				<u> </u>		<b>~</b> / ~	1	/ <del></del>		
*100* Purchasing Purchasing		Memo Issue P/O: Descriptio Possible S	21818 nr: SS locknut with nylon upplier: Acklands P/N: F elease note required						X <u>J</u>	_311/0	1951	100	_	
110		Receive & Inspect for l	Damage & Mat'l Certs	0.00							/ . / /		_	
*110* Packaging		Memo	etarial Delegge Note is et	0.00						13	14/2	6(1	ن سر	
Packaging  120 *120*		QC6- Inspect dimension	aterial Release Note is at	DAS 27 0.00 9-8	, 9 }			/00	a				<b></b>	
QC		Memo		0.00 13 11	1d/									

											DQ	A:	Date:	
NCR: Y	'es	/ No				<b>WORK ORDER NON-</b>	COI	NFORN	/ANCE / UP	DATE				
											QA Close	ed:	Date:	
Work Orde						DISPOSITION				AGAINST DI	PARTME	NT/PROCES	SS	
Part No.  NCR No.				Rework Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite				Wate Prod. Eng. C tore/Packa Sup	Engineering Quality Other					
Root					Descri	otion of work order update	Ţ	Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty	c	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verific	cation	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
		****	-				FAUL	LT CATE	GORY					
Landir	_				<u></u>	General		-			7			1_ /
		Bending Centre Not Concentric to O/S			)/s	Bend BOM/Route Broken/Damaged		Grain Hardwa	re on Incomplete		Ovalized Over/Und Part Incom	der tolerance	e	Pressure/Forced Temperature/Cure Weld
		Cracks Crushed/Crimped		Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost,	/Missing		Wrong Stock Pulled		
	-	Cuffs Heat Treat				Contamination Countersink		Mainte Mislabe			Part Mov Positione			
		Inspection Strip in Tube Ripples in Bend			Cut Too Short Drill Holes	-	Misread Offset			Power Lo	ss/Surge		Other	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 108429 October-17-13 1:30:40 PM				Page 2						
Item ID: Revision ID: Item Name:	D3015-7 Lock Nut		A	*N90004		<b>0040</b>	1100	* Set	tup Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	10/17/13 10/17/13	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*		Cust Ite Custome					
Approvals:		n:		Tooling: SPC (Y/N):		Date:		Ru	n Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 130 *130* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ck Location: <u>570</u> J3	Set Up/ Run Hours 0.00	Tool I	D Tool #		Qty	Qty	Reject Insp. Number Stamp
140 *140* QC Quality Control		QC21- Final Inspection -  Memo	Work Order Release	0.00					13/	11/29 D MF 13/1-28

						,				DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE			*
		· · · · · · · · · · · · · · · · · · ·								QA Closed:	Date:	
Work Order:	•				DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Part No.					Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor	Engineering Quality
NCR No.					Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator		į				i						
Material	1											
Setup												
Other	]											
Process	1											
Supplier												
Training	1											
Unapproved		<u> </u>	J			Т.				<u> </u>		
					·	AUI	LT CATE	GORY		······	<del></del>	
Landing	7			Γ-	General		1		Γ	1	F	L
1	Bending			1	Bend	1	Grain		1	Ovalized		Pressure/Forced

naing	Gear		General			
	Bending		Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S		BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks		Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
L	Crushed/Crimped		Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs		Contamination	Maintenance	Part Moved	
L	Heat Treat	L	Countersink	Mislabeled	Positioned Wrong	_
	Inspection Strip in Tube		Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend		Drill Holes	Offset		
	Torque Waves in Extrusion		Drawing	Out of Calibration		
	Turning Sequence		Finish	Out of Sequence		
Γ	Wave/Twist in Tube		Folio	Outside Dimensions		

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المدائمون كأ

Picklist Print

October-17-13 1:30:39 PM

Work Order ID:

108429

Parent Item:

D3015-7

Parent Item Name:

Lock Nut

**Start Date: 10/17/13** 

Required Date: 10/17/13

Page 1

Start Qty: 50.00

Required Qty: 50.00

**Comments:** 

IPP: A01.06.08New Issue SM

11.01.06 CHG

	Supplier p# DD	vef:EC												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
PFSLNNM5S1		Purchased	No	- <del></del>	<del></del>	100	Each	0.0000	1	100 100	0 /	/3/4/	46 (	100

IPP rev:B

										DQA:	Date	<b>:</b>
NCR: Y	es / No				WORK ORDER NON-C	CON	IFORN	MANCE / UP	DATE	OA Classel	Data	,
										QA Closed:	Date	?: 
Work Orde	ar:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG					Rework			Skid-tube	Crosstube	]	Water Jet	Engineering
Part N	lo.				Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-			<del></del>	1 'h			Finishing	Rec/Sto	re/Packaging	Other	
NCR No.				Work Order Update	1		Large Fab	Composite	]	Supplier		
Root				Descri	ption of work order update	Ir	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						Ì						
Operator												
Material												
Setup		1										
Other							Í					
Process												
Supplier												
Training		1										
Unapproved		<u> </u>				<u>L</u>						
						AUL	CATE	GORY				
Landi	ng Gear			_	General				<del></del>	1	_	<del>_</del>
:	Bending			<u> </u>	Bend	-	Grain			Ovalized	<u> </u>	Pressure/Forced
	<del></del>	ot Conce	ntric to (	o/s  _	BOM/Route	$\vdash$	Hardwa			Over/Under	<del>-</del>	Temperature/Cure
	Cracks				Broken/Damaged	$\vdash$	•	on Incomplete	<u></u>	Part Incorre	<b>j</b> —	Weld
	Crushed/Crimped		Burrs	-		ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs		Contamination	$\vdash$	Mainte			Part Moved				
	Heat Treat		Countersink	Ш	Mislabe	led		Positioned V	Vrong	_		
	Inspection	Inspection Strip in Tube		1	Cut Too Short Misread				1	Power Loss	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

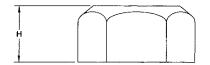
Drill Holes

Drawing

Finish

Folio

## **SPECIFICATION CONTROL DRAWING**



## **D3015-X LOCKNUT**

	PART NUMBER	SIZE	HEIGHT H	POSSIBLE SUPPLIER
	D3015-1	1/4-20 UNC	0.31	ACKLANDS, P/N PFSLNNC14S1
i	D3015-3	5/16-18 UNC	0.34	ACKLANDS, P/N PFSLNNC516S1
	D3015-5	7/16-14 UNC	0.46	ACKLANDS, P/N PFSLNNC716S1
۵l	D3015-7	M5	0.19	ACKLANDS, P/N FLMN021-005-0000

108429 MLJ 13-10-21

REFORMAT DWG, -7 P/N NOW FLMN021-005-0000 WAS LNNM5S1 (ZN B8-1), PAR 09-020 09.07.08 В ADD D3015-7 KJ 03.07.15 NEW ISSUE Α DS 01.05.03 REV. DESCRIPTION BY DATE DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. C D3015 MFG. APPR. SHEET 1 OF 1 APPROVED TITLE SCALE **LOCKNUT** DE APPR. NTS COPYRIGHT © 2001 BY DART ALROSPACE LTD
his socialist is retivate who condition that is supplied on the Express combine
not to be used for any purpose on come on commandation to many only in DATE 09.07.08

NOTES:
1) MATERIAL: SS LOCKNUT WITH NYLON INSERT
2) FINISH: N/A
3) TOLERANCES: ALL DIMENSIONS SHOWN AS REFERENCE
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: N/A

D

7) WEIGHT: N/A

8

3



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

## **PURCHASE ORDER**

## Purchase Order ID PO21818

Purchase Order Date 10/24/2013 PO Print Date 10/24/2013

Page Number 1 of 1

Order From:

ACKLANDS - GRAINGER INC.

P.O. BOX 2970

WINNIPEG, MB R3C 4B5

CA

VC-ACK001

Ship To: DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

**CANADA** 

**Contact Name** 

**Vendor Phone** 

Ship To Contact

Ship To Phone

Ship Via:

Ship Acet:

613 632 2739

Buyer

Chantal Lavoie

Delivered

**Customer POID** Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ CD Taxable Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extende Prio
	AS PER DWG D3015 REV. C B108429	Locknut	10/29/2013 Yes 10/29/2013	100.00 Each	\$0.09	\$9.0
					Line Total:	\$9.0

PFS-LNNC5/16S1

Lock Nut

10/29/2013

Yes 10/29/2013

100.00

\$0.12

\$12.0

AS PER DWG D3015 REV. C

B108415

Line Total:

\$12.0

PO Total:

\$21.0

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer. No substitution or deviation without consent.

Certificate of Conformity or Material Certification required - NO NO

PST# 6122-5207

I

Change Nbr:

Change Date:

10/24/2013

ACKLANDS ACKLANDS - GRAINGER INC. 765 CAMERON ST. PACKING SLIP ONLY INVOICE TO FOLLOW GRAINGER. ACKLANDS - GRAINGER INC. PO BOX 2970 **HAWKESBURY ON K6A 2B7** PAGE PAGE NO (613) 632-2739 WINNIPEG MB R3C 4B5 PACKING SLIP# EXPED T O ACTUREZ ₿ 1417 0430644 1 of 1 DART AEROSPACE LTD S H I P À DART AEROSPACE LTD L 1270 ABERDEEN ST HAWKESBURY 1270 ABERDEEN ST HAWKESBURY K6A 1K7 ON K6A 1K7 À NO. DU CLIENT CUST, NO NO DE REFERENCE DU CLIENT CUST. REF. NO. NO. DE LICENSE PROVINCIALE P.S.T. LIC. NO. NO. DU CONTRAT CONTRACT NO. EXP. DIRECTE DATE DE LA COMMANDE DIR. SHIP ORDER DATE DATE DE LA FACTURE INVOICE DATE 21818 1726280 N/A - HST 10/25/2013 11/26/2013 ENDEUR SALESPERSON TERMES TERMS NO.DE VERSEMENTS NO. OF PMTS. M.E.P. M.B.P. DATE DU PREMIER VERSEMENT FIRST PAYMENT DATE APP. DE CREDIT S'APPLIQUE AU NO.DE FACTURE APPLY TO INVOICE NO. T.P.S/G.S T COPIES M85 -NET 30 \*\*\* O 00/00/0000 08:30 MFG CODE ORDER SEQ. NO. DE PIECE ITEM NO. PRIX DE LISTE SUGG. LIST QUANTITE COMMANDEE QUANTITY ORDERED QUANTITE EXPEDIEE QUANTITY SHIPPED INITE DE MESU DE COMMUNO ORDER UNIT OF MEASURE PRIX EXTENSIONNE EXTENDED PRICE PRIX PRICE PRORE DE TABLETTE BIN LOCATION DESCRIPTION PAR PER ESC DIS MEF 51730.050.001 15.51 100 100 EΑ 9.00 NUT LOC NYL 304SS 985 M5 100 9.00 NYY FLMN021-005-0000 SUPERSEDED BY ABOVE ITEM PRIGINAL B.O. QTY: 100, STILL TO COME: 0NON-STOCKING ITEMS, DELIVERY TIMES WILL VARY. FILLS BACKORDER FROM INVOICE# 0429854, DATED 10/25/2018 HST# 88970-1272/TVQ# 1019602903 SOUS TOTAL / SUB TOTAL EXPEDITEUR SHIP VIA 9.00 DATE DE LIVRAISION REQUISE REQUESTED DELIVERY SHP MV SHPOOMPLETE PORT PAYE PPO FREIGHT CUSTOMER PICK UP CODE DE COMM. DIF. B.O. CODE B - B.O COMMANDE DIF, C- ANNULEE CANCEL D- EXP DIRECTE DIR SI 1.17 9305 RECU PAR RECEIVED BY 0.00 102 10.17 MONTANT TOTAL TOTAL AMOUNT

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